

April-01-15 1:04:33 PM

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Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 4/01/15 **Start Qty:** 16.00 ***16***

Cust Item ID:

Required Date: 4/08/15 **Req'd Qty:** 16.00 ***16***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC(Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4212	C

100

0.00

100

Mill Conv

Conventional Milling Machine

Memo

0.00

1-Turn as per folio FA974 & dwg

FOLIO REV: N/A
DWG REV: C

2-Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

OC

Quality Control

Memo

0.00

16 0 J.C. - 6
15/04/29

16 ~~Ø~~ J.C., -L.
5/04/20

Work Order ID 131261

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131261

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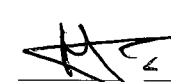
Item ID: D4212-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 429 Clamp Cushion
 Start Date: 4/01/15 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 4/08/15 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

130	Identify as per dwg & Stock Location: <u>5T545</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									

DAS
6
9-89

16  APR 30 2015

140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MCS MAY 04 2015



Picklist Print

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Work Order ID: 131261

131261

Parent Item: D4212-1

D4212-1

Parent Item Name: 429 Clamp Cushion

Start Date: 4/01/15

Required Date: 4/08/15

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A NEW ISSUE 10-09-29 JLM VERIFIED BY:DD IPP
REV:B 11.01.10 AS PER DWG REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-1		Manufactured	No			100	f	25.0360	0.3708	7			

D4287-1

Uhmw U-Channel

Location

Loc Qty

Loc Code

ST479a

25.036

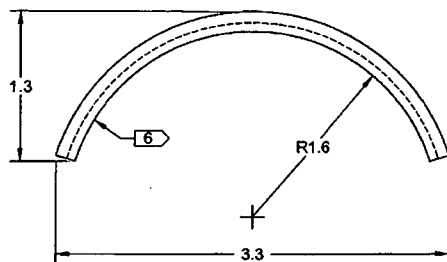
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25.036

131542

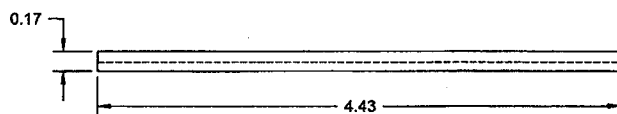
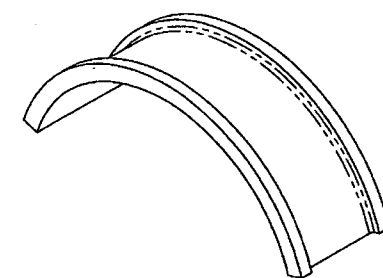
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J.C.-L
15/04/28

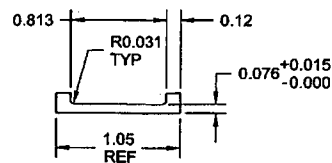


D4212-1 CLAMP CUSHION
(MAKE FROM D4212-1F)

WLO 131261



D4212-1F FLAT MACHINED STATE



RELEASED
2010-12-23

- NOTES:**
- 1) MATERIAL: MAKE FROM D4287-1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4212-1" AND B/N "BXXXXX" PER QSI 044 6.1
 - 7) WEIGHT: 0.02 lbs

C	ADDED FLAT MACHINED STATE; CHANGED DIMENSIONS IAW MANUFACTURING PROCESS. REF: PAR10-29.	MB	10.12.07
B	REDESIGN TO REDUCE COST: "CLAMP CUSHION" WAS "429 CLAMP CUSHION"; MAT'L WAS MUHIMWTR3.500W.XXXW (ZN A7-1)	MB	10.10.26
A	NEW ISSUE	MB	10.09.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.07		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4212	REV. C
TITLE CLAMP CUSHION	SCALE NTS
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